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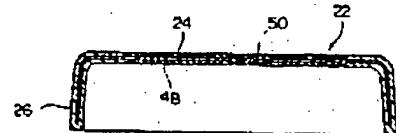
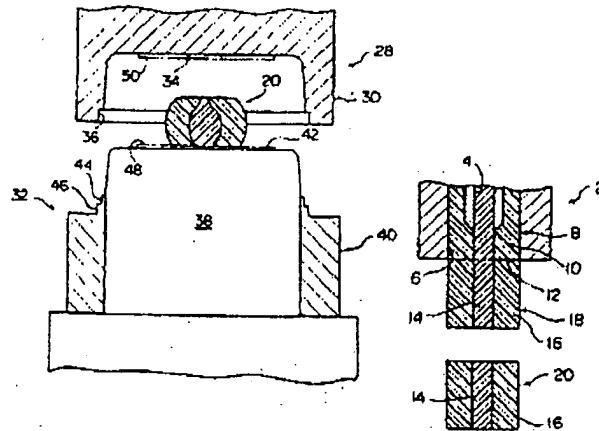
APPLICATION DATE : 06-10-88
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TITLE : MANUFACTURE OF COMPRESSION MOLDING HAVING MULTILAYER STRUCTURE



ABSTRACT : PURPOSE: To manufacture a multilayer structural compression molded material having necessary characteristics at a comparatively low cost, by a method wherein a composite synthetic resin material containing an inside synthetic resin layer and outside synthetic resin layer surrounding the side of the inside synthetic resin layer is generated and compression-molded in an axial direction.

CONSTITUTION: A composite synthetic resin 18 containing a cylindrical inside synthetic resin layer 14 and an outside synthetic resin layer 16 surrounding coaxially the side of the circumference of the inside synthetic resin layer 14 is extruded through an extruding machine 2, cut off in a lateral direction to the axial direction and a composite synthetic resin material 20 is generated. The composite synthetic resin material 20 is supplied to the central part of the top of a cylindrical part 42 of a lower male mold 32 and compressed in the axial direction. The inside synthetic resin layer 14 is extended to almost the whole of a vessel lid 22, in the vessel lid 22 compression-molded finally. The inside synthetic resin layer 14 is exposed to the outside before compression molding and the same is exposed to the central part of both the inside and outside of a top wall 24 in also the compression-molded vessel lid 22. Such exposure is limited to an extraordinary small part of a compressed surface and generation of ply separation between the side synthetic resin layer 14 and outside synthetic resin layer 16 resulting from the same is nil.

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